

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75090

October-17-11 1:21:41 PM

75090

Page 2

Item ID: D3506-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Doubler

Stop

NS2

Start Date: 17/10/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00
~~50~~
~~BC~~

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp***130***

QC

Quality Control

Memo

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

140

QC8- Inspect parts - second check

0.00

09/11/09

0.00

*36 8****140***

QC

Quality Control

Memo

0.00

150

Small Fab

0.00

150

Small Fab

Memo

0.00

Small Fab

C'sink as per Dwg D3506(On Flat side)

EP 11/11/09 36

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75090

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Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Doubler

Stop

NS2

Start Date: 17/10/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

160

160

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

Sulwari

X36

170

170

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

36 BK 11-11-09

180

180

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

36 X Smpu/11/09

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Work Order ID 75090

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75090

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Item ID: D3506-1

Accept

N900040100

Setup

Start

NS1**Revision ID:****Item Name:** Doubler

Stop

NS2**Start Date:** 17/10/2011 **Start Qty:** 20.00***20*****Cust Item ID:****Required Date:** 04/11/2011 **Req'd Qty:** 20.00***20*****Customer:****Reference:****Approvals:****Process Plan:****Date:****Tooling:****Date:**

Run

Start

NR1**QC:****Date:****SPC (Y/N):****Date:**

Stop

NR2**Sequence ID/
Work Center ID****Operation
Description**

190

Identify as per dwg & Stock Location:

63

1Q0

Packaging

Packaging

**Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

200

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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Picklist Print

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Page 1

Work Order ID: 75090

75090

Parent Item: D3506-1

D3506-1

Parent Item Name: Doubler

Start Date: 17/10/2011

Required Date: 04/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-05-31 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100		Purchased		No		110	sf	108.4000	0.0078	0.164211			**

M6061T6S 100

6061-T6 .100 Sheet

Location	Loc Qty	Loc Code
MAT021	108.4	
102201	1	
118072	22.9	
118523	84.5	118072

111-10-18

3K

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DART AEROSPACE LTD	Work Order:	75090
Description: Doubler	Part Number:	D3506-1
Inspection Dwg: D3506	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: JK / SL

Audited by:	<i>ark</i>
Date:	11/103

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.09	New Issue	KJ/JLM	E

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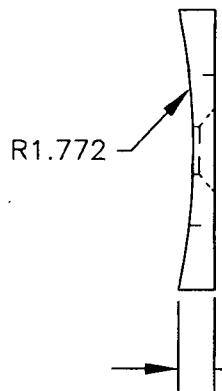
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

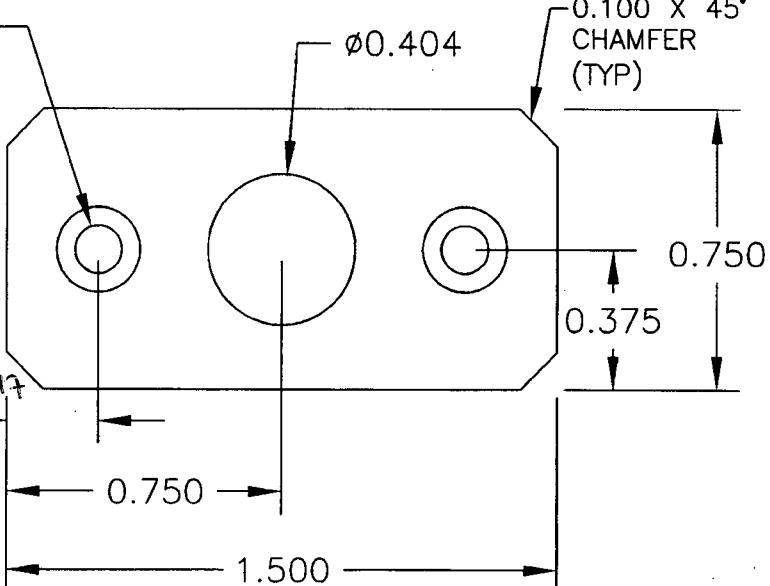
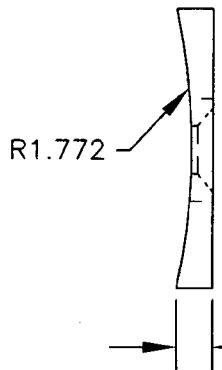
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3506	SHEET 1 OF 1
DATE		TITLE	SCALE
06.04.21		DOUBLER	2:1
A	06.04.21	NEW ISSUE	

PILOT $\phi 0.128$ C'SINK $\phi 0.228 \times 100^\circ$
(2 PLACES)

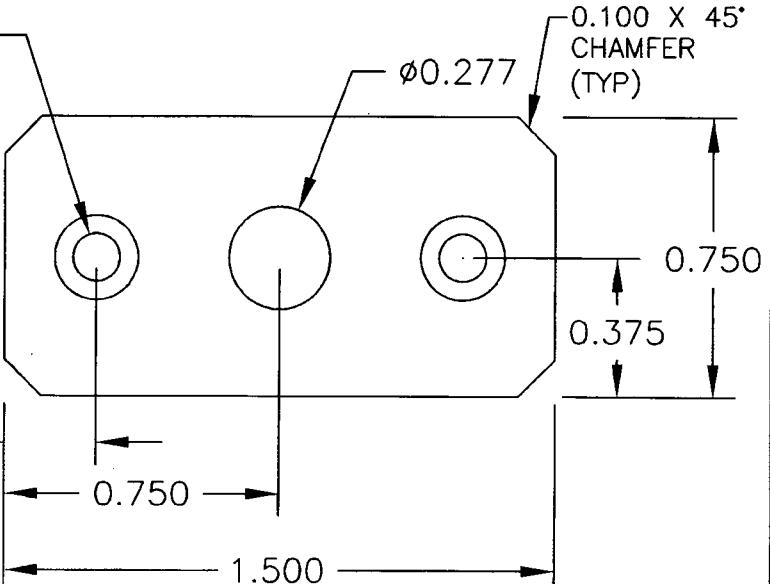
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 7509.0

M.L.3
0.250
(TYP)

11017

**D3506-1 DOUBLER**PILOT $\phi 0.128$ C'SINK $\phi 0.228 \times 100^\circ$
(2 PLACES)

0.250
(TYP)

**D3506-3 DOUBLER****D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
06.10.03 PT
per EN#361

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